



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2572
Job Sheet 200382



Part No: D2572

Job Qty: 10 pcs

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	10 pcs		10/8/19	0.00	0.00	HAAS - 1		SBL 19/10/23
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	10 pcs		10/8/19	1.00	16.13	HAAS - 1 - B4B		SBL 19/10/28
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	10 pcs		10/8/19	0.00	1.60	Conventional Mill - 1 - B4B		SBL 19/10/28
							Conventional Mill - 2 - B4B		
120	QC 2	10 pcs		10/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Container No: S225353



Part: D2572
Job No: 200382
Serial No/Batch: S225353
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/19



Container No: S225353



Part: D2572

Job No: 200382

Serial No/Batch: S225353

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 10/22/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	SB L 19/10/28
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	10 pcs	10/8/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS
				QC 8 - 52	52
				QC 8 - 23	9-89
				QC 8 - 57	19/10/28
				QC 8 - 76	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	10/8/19	0.00 0.41	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ NOV 04 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

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						B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	10 pcs	10/8/19	0.00	0.38	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	10 pcs	10/8/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	10 pcs	10/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	10/8/19	0.00 0.00	QC 21 - SA - 21 ✓	ST398
				QC 21 - SA - 70	21
				QC 21 - SA - 53	2-88

NOV 28 2019

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 502535 Double check by: SL 1-Machine Step No 1
 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 pcs (1 ea)	90-Machining - Issue SN	9x 5184712 1x 5196167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	10	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Inboard	1.174Inches + 0.010	1.184		

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			- 0.000	1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD		Work Order:	200382
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.740	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.996	7.997	7.997		
F	0.490	0.510		.497	.499	.498	.497		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.498	.498	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.565	.568	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.132	.135	.133	.133		
Q	0.115	0.135		.125	.125	.125	.124		
R	0.240	0.260		.250	.250	.260	.248		
S	0.115	0.135		.129	.130	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.246	.239	.239		
W	0.115	0.135		.130	.125	.126	.127		
X	0.307	0.312		.312	.312	.312			
Y	0.760	0.765		.760	.760	.760			
Z	0.352	0.372		.363	.362	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.622	.622	.623		
AC	0.053	0.073		.063	.067	.065	.063		
AD	0.240	0.260		.250	.250	.249	.249		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.257	.258	.260	.260		
AH	0.240	0.260		.252	.252	.248	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033			

Accept/Reject

DAS

52

89

Measured by:	SBL/11/18
Date:	19/10/24

Audited by:	
Date:	19/11/01

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	200382
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				45	26	87	88		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1,750	1,750	1,750	1,750		
C	3.495	3.505		3,500	3,500	3,500	3,500		
D	1.745	1.755		1,750	1,750	1,750	1,750		
E	7.990	8.010		7,997	7,997	7,997	7,997		
F	0.490	0.510		496	497	496	495		
G	0.257	0.262		257	257	257	257		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510		498	497	498	498		
J	1.174	1.184		1,179	1,179	1,179	1,179		
K	0.558	0.578		566	565	566	565		
L	1.174	1.184		1,179	1,179	1,179	1,179		
M	1.490	1.500		1,495	1,495	1,495	1,495		
N	2.495	2.505		2,500	2,500	2,500	2,500		
O	3.869	3.879		3,874	3,874	3,874	3,874		
P	0.115	0.135		130	130	128	131		
Q	0.115	0.135		125	124	124	125		
R	0.240	0.260		249	248	249	249		
S	0.115	0.135		128	130	128	129		
T	0.178	0.198		188	188	188	188		
U	2.940	2.980		2,960	2,960	2,960	2,960		
V	0.230	0.250		238	239	238	239		
W	0.115	0.135		126	126	128	127		
X	0.307	0.312		312	312	312	312		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		363	363	364	364		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		622	622	626	621		
AC	0.053	0.073		064	063	062	063		
AD	0.240	0.260		248	249	249	249		
AE	1.375	1.395		1,355	1,385	1,385	1,385		
AF	0.115	0.135		130	135	135	135		
AG	0.240	0.280		260	260	260	260		
AH	0.240	0.260		250	251	252	253		
AI	2.000	2.020		2,000	2,000	2,000	2,000		
AJ	0.023	0.043		033	033	033	033		
Accept/Reject							52		

Measured by:	SBL
Date:	19/10/27

Audited by:	289
Date:	19/11/01

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 200382
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.997	7.997				
F	0.490	0.510		.496	.496				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.497	.495				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.565	.567				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.138	.132				
Q	0.115	0.135		.124	.124				
R	0.240	0.260		.244	.250				
S	0.115	0.135		.129	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.128	.128				
X	0.307	0.312		.312	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.622	.621				
AC	0.053	0.073		.065	.065				
AD	0.240	0.260		.249	.249				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.263				
AH	0.240	0.260		.252	.251				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: GBL
Date: 12/10/28

Audited by: 52
Date: 9-89 12/10/01

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (Q51042)	
Description Work Order Deviation		Disposition			
Completed By		Lead hand / Supervisor			
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				